

Work Order ID 73750

Wednesday, September 14, 2011 12:08:16 P



Page 1

Item ID: D3293-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 9/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 9/14/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3293

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3293

☐ Dwg Rev:

A

☐ Prog Rev:

A

☐ 2-

Debur if necessary

1311-9-28

[Signature]

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1311-9-29

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

[Signature]

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
	Memo	0.00							
	1- Deburr								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								
150 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00							
	Hand Finishing								

8 BK 11-9-28.

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 3

Accept

Figure 1

Setup Start

Stop

Abstract

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Stop

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

Accept Qty

Reject
QtyReject
Number

**Insp.
Stamp**

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3.

0.00

Powdercoat

Memo

START TIME:

□OVEN TEMPERATURE:

FINISH TIME:

170

QC3- Inspect Part Finish

0.00

[illegible]

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location. 21

0.00

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/30

MF

11-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 14, 2011 12:08:13 PM

Page 1

Work Order ID: 73750

Parent Item: D3293-1

Parent Item Name: Doubler



Start Date: 9/14/2011

Required Date: 9/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: ☐A☐04.08.24☐New issue☐KJ/JLM☐
IPP Rev:B Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	197.3000	1.8264	15.38021			
2024-T3 .080 sheet													

B11-9-08

Location

Loc Qty

Loc Code

MAT022

197.3

105411

6

109424

4

110347

0.5

112331

3

113796

7

114025

15.7

116604

5.8

117392

40.1

118180

115.2

118180

(8)

W/O:		WORK ORDER CHANGES					
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		TITLE	SHEET 1 OF 1
04.06.28		DOUBLER	SCALE
A	04.06.28	NEW ISSUE	1:3

D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

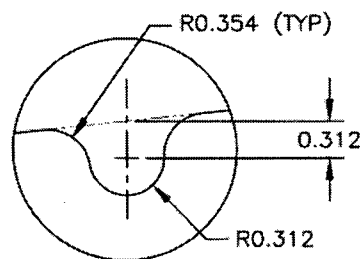
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANOTEX (REF. 4.3.5.7) PER

DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DETAIL A SCALE 2:3



RELEASED
04.07.12

